



Dart Aerospace Ltd.
1270 Aberdeen St
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D2652**Job Sheet 206183****Part No:** D2652**Job Qty:** 300 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/27/20**Job Tracking No:****Due Date:** 3/24/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP Rev:B 02.06.13 Now machined in house. NG**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Hardinge - 1	300 pcs	3/24/20	3/24/20	0.50	11.04	Hardinge - 1	BM-20-03-05
110	QC 2	300 pcs	3/24/20	3/24/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

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**Container No:** S261002**Part:** D2652**Job No:** 206183**Serial No/Batch:** S261002**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 03/05/20

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120 QC 8	300 pcs	3/24/20	0.00	0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	300 pcs	3/24/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	

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					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140 QC 21 - SA	300 pcs	3/24/20	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	53
					Broussard	MAR 11 2020

Part Op **100** - (Hardinge) 1-TURN AS PER FOLIO FA252 & DWG D2652
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.500	303 Round Bar 0.500"	16.5000 ft (0.55 ea) 0.058 ea	100-Hardinge - 1	5257564

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303R0.500	17	100	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.600inches ± 0.010	0.610 0.590	0.602	PJ-05
2	Bushing	0.060inches ± 0.005	0.065 0.055	0.061	PJ-05
3	Bushing	0.305inches + 0.000 - 0.002	0.305 0.303	0.304	FL-01
4	Bushing	0.191inches + 0.005 - 0.001	0.196 0.190	0.191	PJ-05 + PIN
5	Bushing	0.500inches ± 0.010	0.510 0.490	0.495	PJ-05
6	Bushing	0.030inches ± 0.010	0.040 0.020	0.030	PJ-05
7	Bushing	20.000Degrees ± 0.010	20.010 19.990	20	PROG.
8	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010	0.012	PROG + Gauge

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

NCR No.		Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS			
Date :		Sequence #:		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐			
		QTY Affected :		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐			
		MRB (Q51042)		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor					
				QC / QA Coordinator					
Root Cause		FAULT CATEGORY							
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐			
Human Factors ☐		Other/Details:							